

Date: Wednesday, 1/2/2008 11:53:09 AM  
 User: David Duval

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D3187-2
Job Number	: 36544		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D31872
This Issue	: 1/2/2008	S.O. No. :	Drawing Number : NCR08-002
Prsht Rev.	: NC	Project Number	:
First Issue	: 1/1	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	: <u>1/08.01.02</u>	Due Date	: 1/9/2008
Checked & Approved By	:	Qty:	1 Um: Each
Comment	:		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31872	Spacepod Floor
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacepod Floor

Pull from stock

Qty1 B 31836

SB 08/01/02

1

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

- Open holes as per dwg

- Debur

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

- Chemical conversion coat per QSI 005

- Powder coat black per QSI 005 4.3.5.7

N/A

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

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Drawing Name: D3187-2

Job Number: 36544

Part Number: D31872

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2986

Black Neoprene foam .125



Comment: Qty.: 1.0000 sf(s)/Unit Total : 1.0000 sf(s)

Black Neoprene foam .125

- Qty 1

- B 30632

SAD 08-01-02 ①

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- Scuff bonding surface, and clean using wash n wipe.

- Bond D2986 onto the D3187-2 floor, using contact cement M 102565

- Trim to fit, per dwg.

SAD 08-01-02 ①

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 08-01-02 ①

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

- Identify and package for shipping

SAD 08-01-02 ①

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SAD 08/01/02 ①

Job Completion



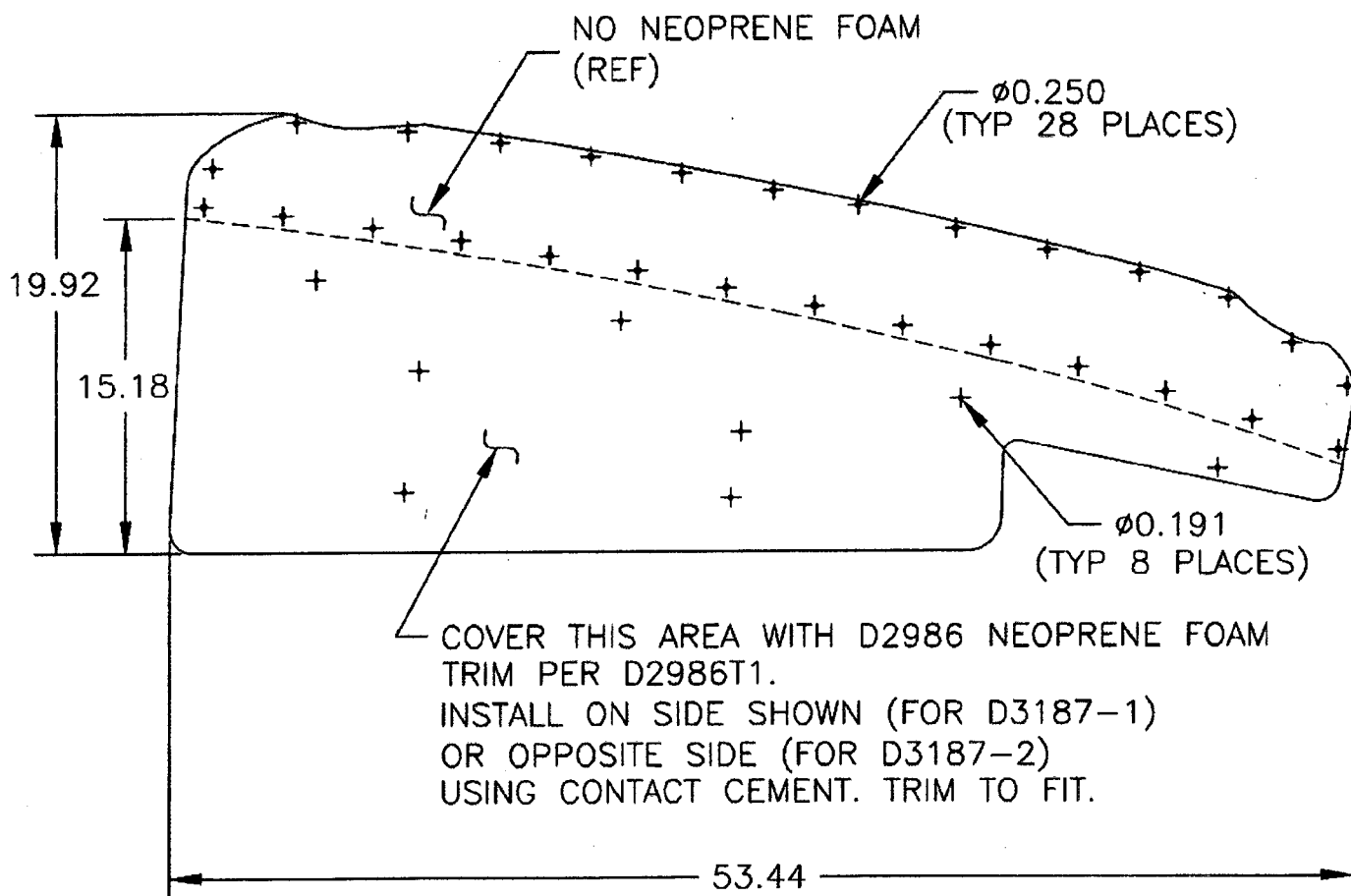
mi 2008/1/2



DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3187	REV. B SHEET 1 OF 1
DATE 03.05.16		TITLE SPACEPOD FLOOR	SCALE NTS
A	03.03.31	NEW ISSUE	
B	03.05.16	CHANGE SHAPE	

RELEASED  
03.06.25

REFERENCE ONLY



D3187-1/-2 SPACEPOD FLOOR

- 1) CUT/DRILL ALUMINUM PER TEMPLATE D3187-1T1
- 2) CUT NEOPRENE FOAM PER TEMPLATE D2986T1
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) ALUMINUM SHEET, 0.050 THICK  
(REF DART SPEC. M6061T6S.050)
- 3) FINISH: BEFORE ATTACHING NEOPRENE, POWDER COAT BLACK SANDTEX (4.3.5.7)  
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

W/O  
36544  
J 0801-02

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